



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
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Canada

Tel (613) 632-5200
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RBE350A93-3717-00

Job Sheet 199164



Part No: RBE350A93-3717-00

Job Qty: 1 pcs

Part Name: Case Seal Replacement Tool



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 8/13/19

Job Tracking No:

Due Date: 10/29/19

Created By: Marie Lajeunesse

Type: SOLD

Description: ORDER 18716

Note: DWG RBE350A93-3717-00 Rev.B IPP Rev. A 18.10.22 New issue DP Verify DD

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
110	Small Fab - 1	1 pcs	10/29/19		0.00	1.00	Small Fab - 1		
							Small Fab - 2		
							Small Fab - 3		
							Small Fab - 4		
							Small Fab - 5		
							Small Fab - 6		
							Small Fab - 7		
							Small Fab - 8		
120	QC 5	1 pcs	10/29/19		0.00	0.00	QC 5 - 10		GP 19-10-15
							QC 5 - 12		
							QC 5 - 17		
							QC 5 - 18		
							QC 5 - 19		
							QC 5 - 22		
							QC 5 - 24		
							QC 5 - 3		
							QC 5 - 43		
							QC 5 - 49		
							QC 5 - 51		
							QC 5 - 58		
							QC 5 - 68		
							QC 5 - 9		
							QC 5 - 50		
							QC 5 - 30		
							QC 5 - 40		
							QC 5 - 61		
							QC 5 - 81		
130	Packaging 3-1 - Stock - B4B	1 pcs	10/29/19		0.00	0.00	Packaging 3 - 1 - B4B		NOV 11 2019
							Packaging 3 - 2 - B4B		
							Packaging 3 - 3 - B4B		
							Packaging 3 - 4 - B4B		

8/13/19

[Dart Hawkesbury] Job Sheet - Lajeunesse, Marie

140 QC 21 - FG	1 pcs	10/29/19	0.00 0.00	Packaging 3 - 5 - B4B	
				Packaging 3 - 6 - B4B	
				Packaging 3 - 7 - B4B	
				Packaging 3 - 8 - B4B	
				Packaging 3 - 9 - B4B	
				Packaging 3 - 10 - B4B	
				Packaging 3 - 11 - B4B	
				Packaging 3 - 12 - B4B	
				Packaging 3 - 13 - B4B	
				Packaging 3 - 14 - B4B	
				Packaging 3 - 15 - B4B	
				Packaging 3 - 16 - B4B	
				Packaging 3 - 17 - B4B	
				Packaging 3 - 18 - B4B	
				Packaging 3 - 19 - B4B	
				Packaging 3 - 20 - B4B	
				Packaging 3 - 21 - B4B	
				Packaging 3 - 22 - B4B	
				Packaging 3 - 23 - B4B	
				Packaging 3 - 24 - B4B	
				Packaging 3 - 25 - B4B	
				Packaging 3 - 26 - B4B	
				Packaging 3 - 27 - B4B	
				Packaging 3 - 28 - B4B	
				Packaging 3 - 29 - B4B	
				Packaging 3 - 30 - B4B	
				Packaging 3 - 31 - B4B	
				Packaging 3 - 32 - B4B	
				Packaging 3 - 33 - B4B	
				Packaging 3 - 34 - B4B	
				Packaging 3 - 35 - B4B	
				Packaging 3 - 36 - B4B	
				QC 21 - FG - 21	
				QC 21 - FG - 70	
				QC 21 - SA - 53	

12 11/11/19

NOV 11 2019

Part Op 110 - (Small Fab) 1-Assemble as per DWG.
 Descriptions: 120 - QC5- Inspect part completeness to step on W/O
 130 - (Identify as per dwg & Stock Location: _____)
 140 - QC21- Final Inspection - Work Order Release)

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
90591A151	Nuts	2 Ea (2 ea)	110-Small Fab - 1	
91280A334	Hex Head Cap Screw	2 Ea (2 ea)	110-Small Fab - 1	
91455A120	Washer	2 Ea (2 ea)	110-Small Fab - 1	
RBE350A93-3717-00-01	Body	1 pcs (1 ea)	110-Small Fab - 1	
RBE350A93-3717-00-03	Half Receiver	2 pcs (2 ea)	110-Small Fab - 1	
91280A342	Hex Head Cap Screws	2 (2 ea)		

5122142
 5122536
 511-138544-1
 5102550-5215
 5188560
 5230401

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
110-Small Fab - 1	90591A151	2	94	0
	91280A334	2	94	0
	91455A120	2	92	0
	RBE350A93-3717-00-01	1	0	0
	RBE350A93-3717-00-03	2	4	0

Part Specifications

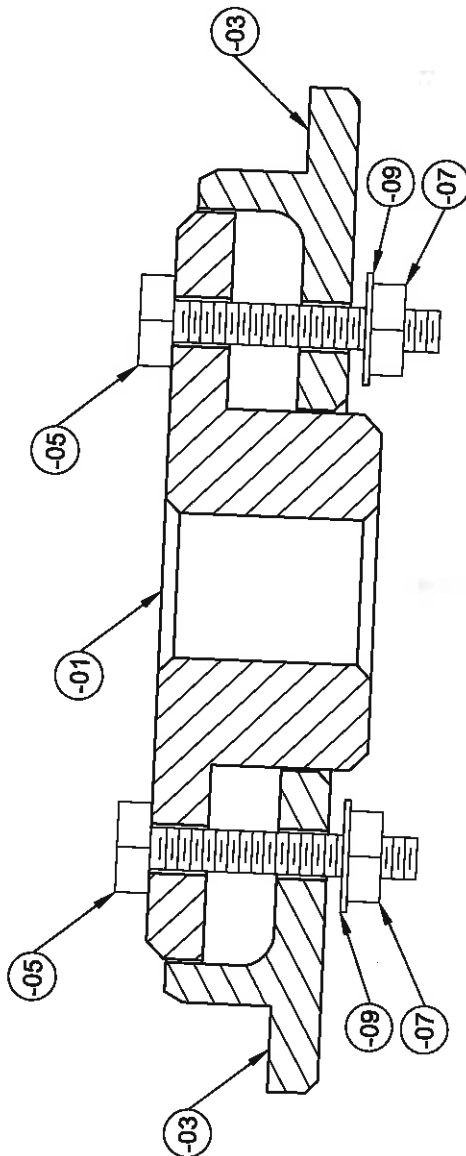
Specifications could not be found.

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REV	DESCRIPTION	DATE	APPROVED
A	ADDED MISSING DIMENSIONS -01 & -03 PER S.E.	11/30/10	RJC
B	CHD TIN WAS RBE350A93-3717-00. -01 & -03 MOVED TO SEPARATE SHEETS, DELETED DUPLICATE DIMS, CHD SPEC ON FINISH WAS MIL-C-81562B, TYPE II, CLASS I IS QQ-P-416F, TYPE II, CLASS I. -05 ADDED B/O INFO #91280A334. -07 ADDED B/O INFO #90591A151. -09 ADDED B/O INFO #91455A120. CHD TOLERANCE ON NON-CRITICAL PARTS. -3 CHD SPEC WAS 06 X 1-1/8 IS 1.0 X 4.5 X 5.50.	5/27/14	DPD RJC

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WORK ORDER
199164 MJS
19-08-13



NOTES:

1. TEST PIECES R.C. 5
2. "AMGC9927" WAS ALSO ENGRAVED ON TOOL

RED BARN MACHINE

CASE SEAL REPLACEMENT TOOL

DWG NO. RBE350A93-3717-00 REV B

UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES
TOLERANCES ON:
DECIMALS .005
FRACTIONS 1/32
ANGLES 1.5°
UNLESS OTHERWISE SPECIFIED 1. BREAK ALL SHARP EDGES 2. DIMENSIONAL LIMITS APPLY AFTER PLATING

DRAWN BY: PERRITT
APPROVED: [Signature]
TEST FINISH
USED ON MODEL EUROCOPTER 350A
SCALE 1:1 DATE 8-13-09 SHEET 1 of 3

ASSY QTY	ASSY #	PART #	UNIT QTY	DESCRIPTION	MATERIAL	B/O INFORMATION OR SPECIFICATIONS	Pg.
		-01	1	BODY	1018	Ø4-1/2 X 1-3/8	2
		-03	2	HALF RECEIVER	1018	1.0 X 4.5 X 5.5 (MAKES TWO HALVES)	3
		B/O -05	2	HEX HEAD CAP SCREW	STEEL	M6x1 X 25mm MCMaster-CARR #91280A334	1
		B/O -07	2	NUTS	STEEL	M6x1 MCMaster-CARR #90591A151	1
		B/O -09	2	WASHERS	STEEL	Ø6mm MCMaster-CARR #91455A120	1

Entered: _____ Date: _____

WORK ORDER NON-CONFORMANCE / ROUTE UPDATE

NCR No. _____

Route update only ☐



Job: _____ Part No. _____		DISPOSITION			DEPARTMENT/PROCESS						MRB (QS1042)		
Date: _____		Sequence #: _____		QTY Affected: _____		Disposition						Completed By	
Description Work Order Deviation		Rework ☐ Scrap ☐ Use-as-is ☐		Skid-tube ☐ Machining ☐ Large Fab ☐		Cross tube ☐ Small Fab ☐ Finishing ☐		Eng. (Non-AW) ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐		Engineering ☐ Water Jet ☐ Supplier ☐ Quality ☐			
Root Cause Operator ☐ Manufacturing Process ☐ Equip/Tooling ☐ Handling/Preservation ☐ Material ☐ Product Improvement ☐ Process Improvement ☐ Human Factors ☐		FAULT CATEGORY											
		Pressure/Forced ☐ Bending ☐ Crushing ☐ Cracks ☐ Crimp/Kink/Ripple/Wave/Twist ☐ Marks/Chatter ☐ Mislabeled ☐ Other/Details: _____		Contamination ☐ Misaligned/off center ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Incomplete/Unclear Instructions ☐ Drill Holes ☐ Fit/Function ☐		Power Loss/Surge ☐ Folio/Program ☐ Grain Direction ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set/Set-up ☐		Positioned Wrong ☐ Outside Tolerance ☐ Drawing ☐ Finish ☐ Part Lost/Missing ☐ Misread ☐					
		Lead hand / Supervisor											
		QC / QA Coordinator											

Linda Lacelle

From: Chantal Lavoie
Sent: Monday, November 11, 2019 7:55 AM
To: Linda Lacelle
Subject: FW: RBE350A98-3717-00

From: Michelle GagnonDonovan <mgagnondonovan@dartaero.com>
Sent: November 6, 2019 10:29 AM
To: Steven Drouin <sdrouin@dartaero.com>; Chantal Lavoie <clavoie@dartaero.com>
Cc: Vanessa Morel <vmorel@dartaero.com>
Subject: RE: RBE350A98-3717-00

Good Morning,

Part is now in Plex.

Thanks,

Michelle Gagnon-Donovan
Document Controller

DART AEROSPACE
T 1 613 632-5300 > 251

www.dartaerospace.com



From: Steven Drouin <sdrouin@dartaero.com>
Sent: Wednesday, November 6, 2019 10:24 AM
To: Chantal Lavoie <clavoie@dartaero.com>; Michelle GagnonDonovan <mgagnondonovan@dartaero.com>
Cc: Vanessa Morel <vmorel@dartaero.com>
Subject: RBE350A98-3717-00

Hi Michelle and Chantal

Michelle: could you enter the following part in PLEX please

91280A342

Description: Medium-Strength Class 8.8 Steel Hex Head Screw, Zinc-Plated, M6 x 1 mm Thread, 40 mm Long

Chantal:

Could you order the following product from McMaster-carr order minimum

91280A342

<https://www.mcmaster.com/catalog%2f125%2f3241>

also could you let me know when this part comes in ?

thank you

steven



Entered: _____ Date: _____

WORK ORDER NON-CONFORMANCE / ROUTE UPDATE

Route update only

NCR No.

Job: <u>199164</u>		DISPOSITION		DEPARTMENT/PROCESS			
Part No. <u>RB330A93-3117-00</u>		Rework ☒ Scrap ☐ Use-as-is ☐		Eng. (Non-AW) Prod. Eng. Coord. Rec/Store/Packaging			
Date: _____		Sequence #: _____		QTY Affected: _____			
Description Work Order Deviation		Disposition					
Hex Head Gap Screw length was Not correct on drawing (PN 91280A334) this should be replace with (PN 91280A342)		Acceptable change, Drawing would need to be updated, and Boom					
Root Cause		FAULT CATEGORY					
Operator Manufacturing Process Equip/Tooling Handling/Preservation Material Product Improvement Process Improvement Human Factors		Pressure/Forced Bending Crushing Cracks Crimp/Kink/Ripple/Wave/Twist Marks/Chatter Mislabeled Other/Details:					
		Contamination Misaligned/off center BOM/Route Broken/Damage/Defect Incomplete/Unclear Instructions Drill Holes Fit/Function					
		Power Loss/Surge Folio/Program Grain Direction Weld Wrong Stock Pulled Out of Sequence Off-set/Set-up					
		Positioned Wrong Outside Tolerance Drawing Finish Part Lost/Missing Misread					
		Completed By <u>GP</u>					
		Lead hand / Supervisor					
		QC / QA Coordinator					

MRB (Q51042)
51
9-8c
19/11/12